

# Work Order ID 85898

June-18-12 1:00:01 PM

**\*85898\***

Page 1

Item ID: D2596

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web, 205 Skidtube

Start Date: 18/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/10

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2596	Rev D								
100		0.00							
<b>*100*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr								
110	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*110*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

4 SAD 12-06-26

4 W/12626

DD 12-6-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85898

**\*85898\***

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June-18-12 1:00:01 PM

Item ID: D2596

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Web, 205 Skidtube

Stop **\*NS2\***

Start Date: 18/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: **4/6**

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

**DP 12-6-27 (4)**

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

**12/6/28 MF 12-06-27**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-18-12 1:00:06 PM

Page 1

Work Order ID: 85898

\*85898\*

Parent Item: D2596

\*D2596\*

Parent Item Name: Web, 205 Skidtube

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM  
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	4.0000	1	4			
*D2500-3-100*									**				
Ext'n - I' Beam Web 4"													

SAD 12-06-26

Location

Loc Qty

Loc Code

LG

4

51957

2

79041

2

B84873

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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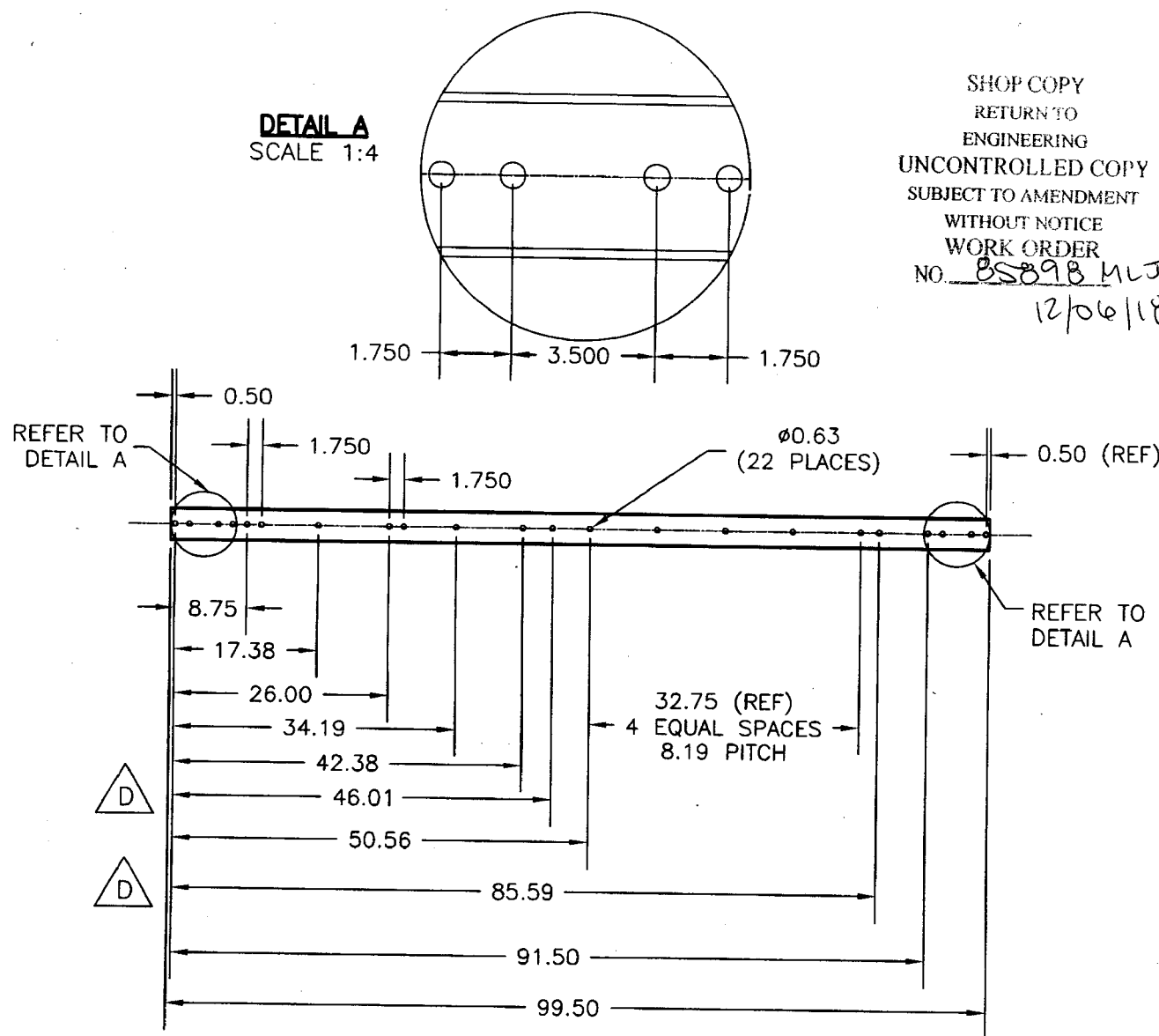
**NOTE:** Date & initial all entries

**DART**

**RELEASED**  
07.06.18

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85898 MLJ  
12/06/18

**DETAIL A**  
SCALE 1:4



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
84	84	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
		D2596	
DATE	TITLE	SCALE	
07.04.17	205 WEB	1:20	
A	96.09.16	NEW ISSUE	
B	97.07.23	0.63 HOLE WAS 0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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